



# Beocycle PE RTM216 Ocean extra UV

## Material Technical Data Sheet

Date of issue: 14/12/2022 Version: 3.0

### SECTION 1: Identification of the substance/mixture and of the company/undertaking

#### 1.1. Product identifier

<b>Product form</b>	: Powder
<b>Name</b>	: Beocycle PE RTM216 Ocean extra UV
<b>Product code</b>	: 9802100216
<b>Application</b>	: Rotomoulding
<b>Composition</b>	: 50% recycled PE + 50% virgin PE and additives
<b>Origin of end-of-use polymers</b>	: This product contains Ocean - a range of post-consumer recycled (PCR) raw material originating from end-of-life maritime gear. The maritime gear is collected , cleaned , sorted and re-used by upgrading the material to a higher quality composite.

#### 1.2. Details of the supplier of the material specification sheet

##### Manufacturer

Beologic  
 Jolainstraat 44  
 8554 Sint-Denijs  
[info@beologic.com](mailto:info@beologic.com)

### SECTION 2: Physical, mechanical and thermal properties

#### 2.1. Information on basic physical, mechanical and thermal properties

Properties <sup>(1)</sup>	Method	Typical Value	Unit
<b>Physical</b>			
Physical state		Solid	
Recycled content		>50	%
Relative density	ISO 1183-1	0,85-0,95	g/cm <sup>3</sup>
MFI (190°C, 2,16 kg)	ISO 1133-1	2-2,5	g/10min
Coloured in mass		No	
Colour material		Green	
UV package		Medium	
Carbon footprint <sup>(2)</sup>	PAS 2050	1,177*	kg CO <sub>2</sub> Eq/ kg
Shelf life <sup>(3)</sup>		6	Months
<b>Mechanical</b>			
Tensile modulus	ISO 527-1	534	MPa
Tensile strength	ISO 527-1	18	MPa
Break stress	ISO 527-1	16	MPa
Elongation at break	ISO 527-1	568	%
Flexural modulus	ISO 178	627	MPa
Charpy impact strength (Notched 1eA , 23 °C)	ISO 179-1	16	kJ/m <sup>2</sup>
Vicat softening point (B120)	ISO 306	58	°C

(1) Typical properties; not to be construed as specifications.

(2) Carbon footprint calculated by Neutrologic

(3) Only if storage conditions (section 5) were followed

\*Due to continuous variation of feedstock this figure reflects value of September 2022. Update latest carbon footprint available on request.

#### 2.2. Product Carbon footprint

The product carbon footprint helps to define the amount of greenhouse gas emissions generated by a product along its life cycle, it quantifies the ghg-emissions related to the production of our products.

Neutrologic calculates the carbon footprint of all sales products and this from cradle to gate.

The calculation of the carbon footprint is in accordance with the internationally recognized Greenhouse Gas Protocol Product Standard which is based on the standard ISO-14067 norm and PAS2050.

The carbon footprint is mentioned in our datasheet - by offsetting or compensating the calculated emissions we can present our products as Carbon Neutral compounds. This compensation is according the Verified Carbon Standard – more info via ([www.v-c-s.org](http://www.v-c-s.org)).



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### 2.3. Circularity and ecology

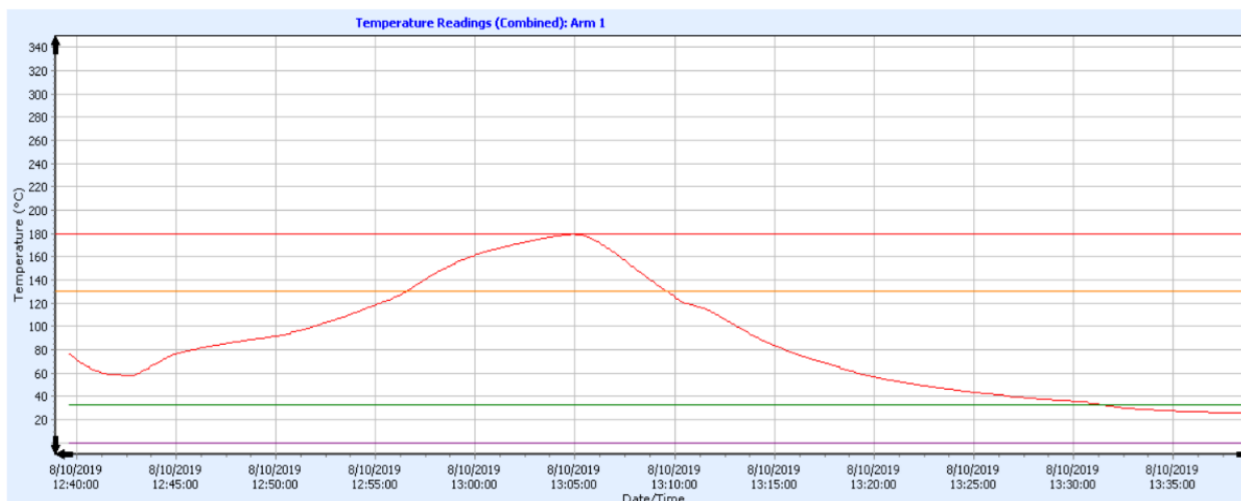
**Beocycle PE RTM216 Ocean extra UV** is a sustainable compound and it has an impact on our ecology as we avoid plastic pollution of our oceans/ of our seas. We are actively working on circularity as we design this product to be durable and recyclable, depending on the end application you could even further decrease CO2 emissions.

By using **Beocycle PE RTM216 Ocean extra UV** as raw material choice you directly contribute to further closing the material loops, reducing landfilling, marine pollution and loss of valuable resources.

## SECTION 3: Processing conditions-guidelines

### 3.1. Processing procedure – lab environment:

1. Procedure based on inner mould temperature/inner air temperature (IAT) measured on lab scale.
2. IAT start at 120°C – 130°C and gradually increase with step of 5°C to 165°C – 175°C.
3. PIAT ≤ 175°C.
4. Residence time : depending on application or product fe. 100 gr – 20 minutes.
5. Check energy absorption of the product.
6. Typical temperature flow chart IAT – see chart below.



### 3.2. Processing measurements- lab scale environment

<b>Powder pick-up temperature (°C)</b>	65 - 75
<b>Optimum PIAT (°C)</b>	165 - 175
<b>Demolding temperature (°C)</b>	60 - 70
<b>Thickness distribution</b>	Excellent

## SECTION 4: General advice

### 4.1. General info

**Beocycle PE RTM216 Ocean extra UV** is not compatible with a wide variety of polyolefins some special sequences should be followed:

1. Before production, ensure to clean equipment and check oven temperature to a controlled condition.
2. Vacuum out on any hopper/blending or other mixture equipment system to avoid contamination.
3. Introduce **Beocycle PE RTM216 Ocean extra UV** into the equipment at the operating conditions.
4. Once **Beocycle PE RTM216 extra Ocean extra UV** is introduced, check inner air temperature.
5. At shutdown, clean your equipment and remove all remaining residue from the mall.

At higher temperature, the dwell time of the material inside the machine shall be reduced to a minimum in order to lower the risk of degradation. Do not leave the material hot inside the machine for long periods as the material will degrade.



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### SECTION 5: Drying and storage conditions

**Beocycle PE RTM216 Ocean extra UV is supplied with a low residual moisture content and does not need any drying.** If the material needs to be dried, we recommend drying **Beocycle PE RTM216 Ocean extra UV** at max 70°C for 4 hours. Don't overheat or dry it longer than recommended. Residual moisture content (> 0.2%) can result in lower melt stability, surface mark or bubble formation during processing.

We recommend to store the material in dry conditions below 50°C and protected from UV-light. Opened (big)bags should be used immediately or adequately sealed back up after use to avoid moisture uptake and have negative effects on the physical properties of the product. It is recommended to use Beocycle powder within a time period of maximum 6 months.

Finished product made from Beocycle should be stored dry and cold. Storage time and lifetime of finished products depends on processing parameters and on storage conditions (moisture, UV radiation ...).